



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PRELIMINARY ISSUE

D5623-043
Job Sheet 181057

Accounting Job RD18-1056-01



Part No: D5623-043

Job Qty: 1 ea

Part Name: Aft Skidtube Protector, LH



Part Weight: 0 lbs

Job Created: 7/20/18

Due Date: 7/27/18

Type: R+D

Note: DWG D5623 REV A - prelim IPP REV A 18.05.22 NEW ISSUE RQ VERIFIED BY DD

Ship Via:

Status: Scheduled

Job Tracking No:

Created By: Marie Lajeunesse

Description:

POSITIVE RECALL

EFFECTIVE 2018-07-21

RELEASED 9-89 DATE 18-09-25

Priority: Medium

as per ECU18-735

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		7/27/18	0.00	0.00	Start Up Waterjet		SC 18/07/23
110	Waterjet	1 pcs		7/27/18	0.00	0.06	Waterjet1		SC 18/07/23
120	QC	1 pcs		7/27/18	0.00	0.00	QC2 Waterjet-2		SC 18/07/23
130	QC	1 pcs		7/27/18	0.00	0.00	QC8-2		38
140	Brake NC	1 pcs		7/27/18	0.12	0.01	Brake NC 1		DAS 9-89 SB
150	QC	1 pcs		7/27/18	0.00	0.00	QC5		38
160	Large Fab	1 pcs		7/27/18	0.00	0.25	Large Fab 1		9-89 7/2
170	QC	1 pcs		7/27/18	0.00	0.00	QC9		67
180	QC	1 pcs		7/27/18	0.00	0.00	QC5		67
190	HandFinish	1 pcs		7/27/18	0.00	0.03	HandFinish4		ET 18-08 DAS
200	QC	1 pcs		7/27/18	0.00	0.00	QC3		SEP 05 2018 68
210	Packaging	1 pcs		7/27/18	0.00	0.00	Packaging3-1		9-89
220	QC21-SA	1 Ea		7/27/18	0.00	0.00	QC21		DAS 21 SEP 27 2018

Part Op 110 - 1-Cut D5623-3F as per Dwg D5623 Dwg Rev: 2 Prog Rev: 2 2-Deburr if necessary

Descriptions: 160 - Tack weld as per dwg. -Index clamp as per dwg note 10

190 - APPLY TEXTURED COATING ON CONCAVE SURFACE ****AS PER NOTE 3**** ON DWG AND QSI

BATCH: 138886

210 - LOCATION : FP001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S20GA	304/316 .040 Sheet	1.1910 sf (1.191 ea)	90-Start up Operation	
MS21920-25	Clamp	1 Ea (1 ea)	160-Large Fab	5082848

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S20GA	1	372	0
160-Large Fab	MS21920-25	1	130	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____		Step #: _____		Container No: S095341 Part: D5623 - 043 Job No: 181057 Serial No/Batch: S095341 Revision: A prelim Inspector: _____ Exp Date: _____ Instructions: _____ Date: 07/23/18 DART AEROSPACE 1270 Aberdeen Street Hawkebury, ON K6A 1K7 CANADA TEL.: 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com			
Description Work Order Deviation							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Force ☐ Bending ☐ Centre Not Cor ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐					
		Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : _____					

DART AEROSPACE LTD		Work Order:	181057
Description: AFT Skidplate Protector, LH		Part Number:	D5623-043
Inspection Dwg: D5623	Rev: 2	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
57.43	+/- 0.030	57.43	1		VSC-01	
55.362	+/- 0.010	55.365	1		Tape	
24.924	+/- 0.010	24.925	1			
21.424	+/- 0.020	21.425	1			
16.299	+/- 0.010	16.300	1			
7.481	+/- 0.020	7.490	1			
4.250	+/- 0.010	4.250	1			
12.79	+/- 0.030	12.80	1			
16.75	+/- 0.020	16.75	1			
2.00	+/- 0.030	2.004	1			
2.40	+/- 0.030	2.408	1			
3.25	+/- 0.030	3.251	1			
3.00	+/- 0.030	3.001	1			
2.20	+/- 0.030	2.204	1			
0.38	+/- 0.030	0.387	1			
0.34	+/- 0.016-0.001	0.345	1			
0.50	+/- 0.030	0.506	1			
0.75	+/- 0.030	0.754	1			
0.38	+/- 0.030	0.389	1			
0.40	+/- 0.030	0.406	1			
0.77	+/- 0.030	0.777	1			
1.00	+/- 0.030	1.005	1			
0.040	+/- 0.010	0.036	1			

Measured by: SC	Checked by: DAS 38	QC Inspector:
Date: 19/07/23	Date: JUL 24 2018	Date:

Engineering Approval: (If necessary)	Date:
---	-------

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

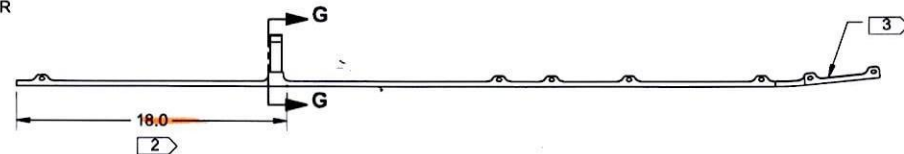
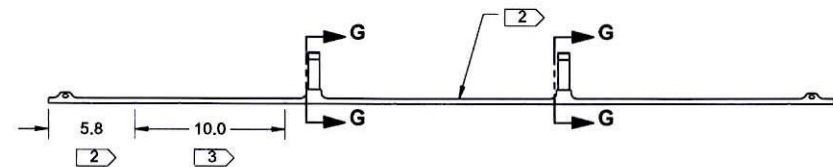
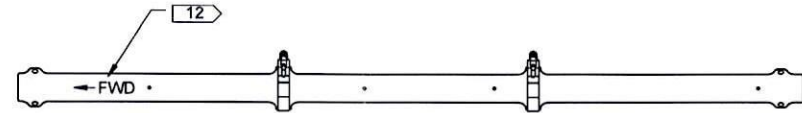
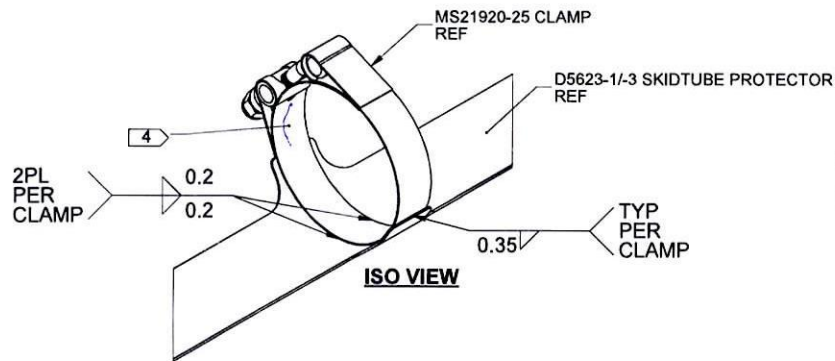
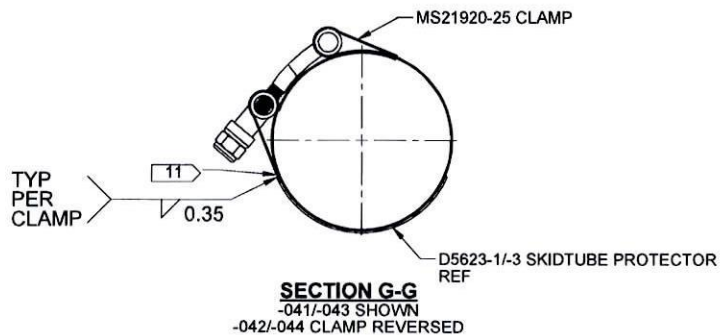
QA Closed: _____

Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D5623-041	FWD WEARPLATE ASSY LH
2		X	D5623-043	AFT WEARPLATE ASSY LH
3	1		D5623-1	FWD WEARPLATE
4		1	D5623-3	AFT WEARPLATE
5	2	1	MS21920-25	CLAMP



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 SECTION 4.9
- 3) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.060-0.080 TOTAL THICK, PER DART QSI 005 SECTION 4.9
- 4) FINISH: COAT ENTIRE INNER (CONCAVE) SURFACE OF MS21920 CLAMP WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 SECTION 4.9
- 5) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) UNITS: INCHES UNLESS OTHERWISE NOTED
- 7) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D5622-X" USING FINE POINT PERMANENT INK MARKER PER DART QSI 044 SECTION 6.1
- 9) WEIGHT: D5622-041 = 1.3 lbs, D5623-043 = 1.3 lbs
- 10) WELDING: PER DART QSI 004
- 11) INDEX MS21920-25 CLAMP TABS WITH WEARPLATE AT THIS LOCATION
- 12) INDICATE FWD DIRECTION IN LOCATION SHOWN USING WHITE PAINT MARKER

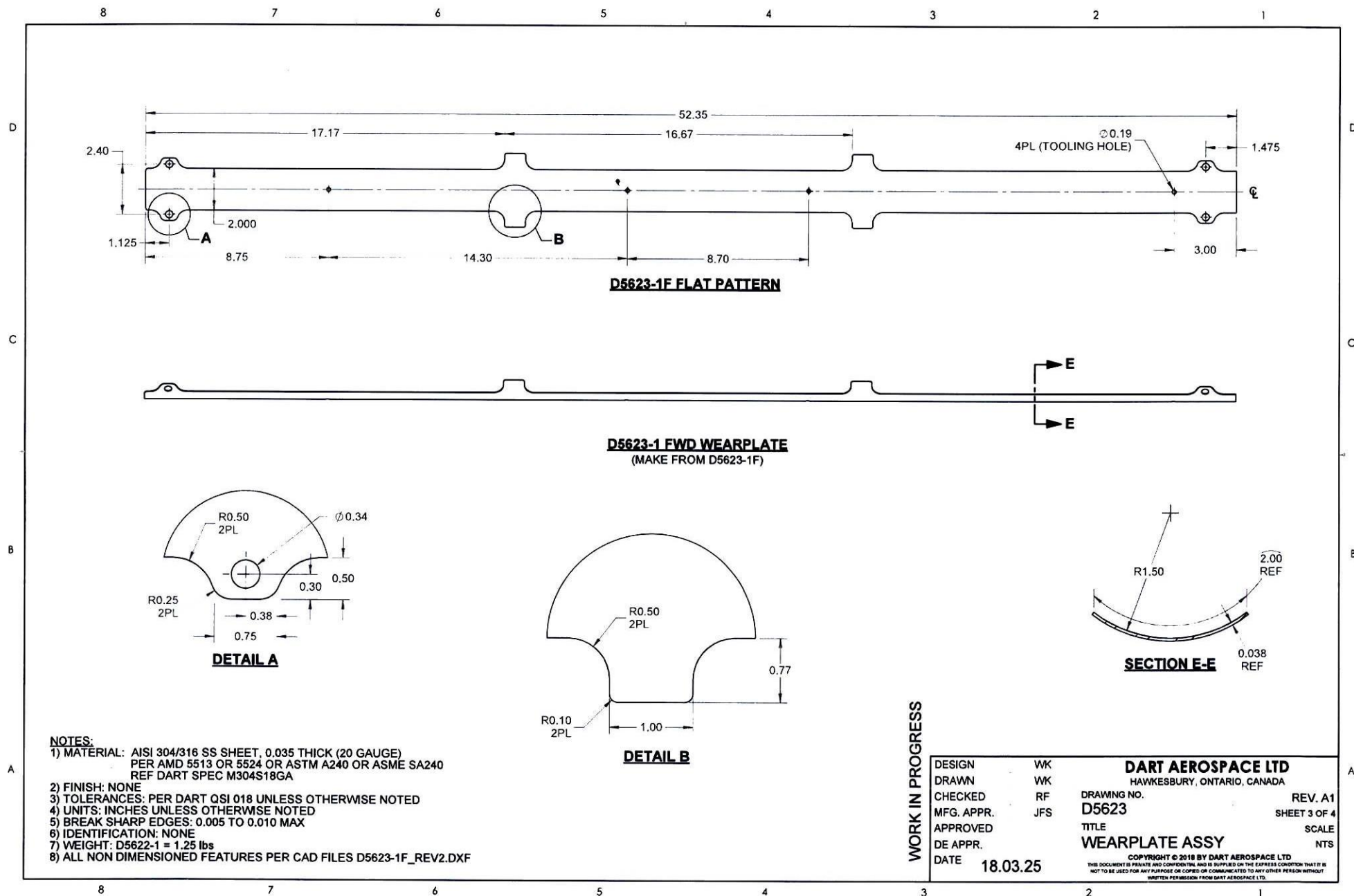
WORK IN PROGRESS

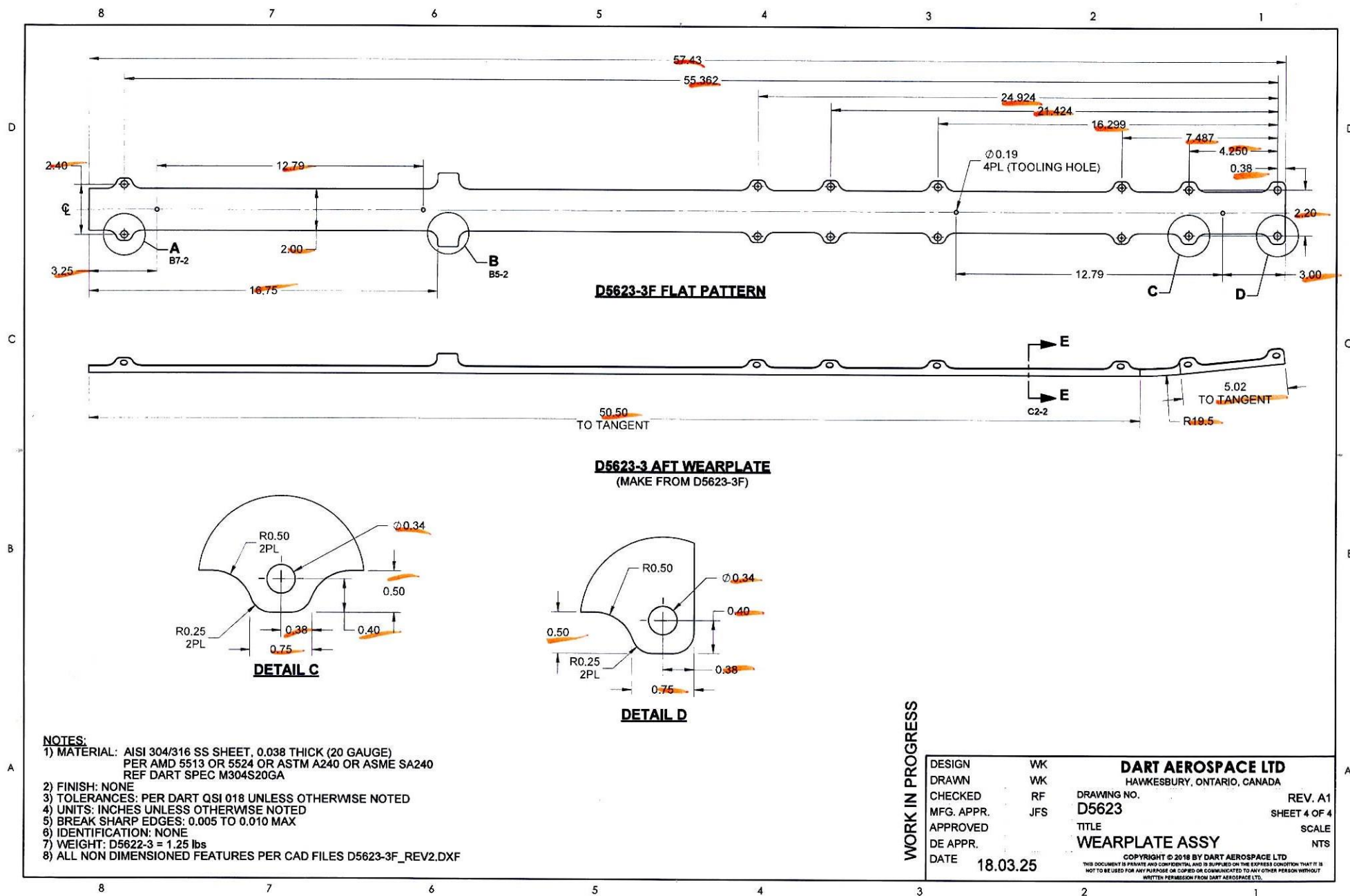
REV.	NEW ISSUE	DESCRIPTION	WK	18.03.25
			BY	DATE
DESIGN	WK			
DRAWN	WK			
CHECKED	RF			
MFG. APPR.	JFS			
APPROVED				
DE APPR.				
DATE	18.03.25			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

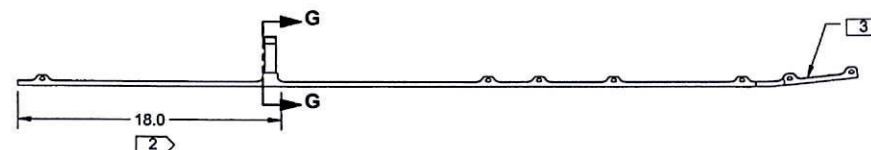
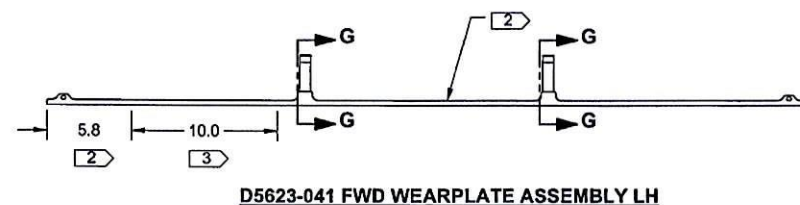
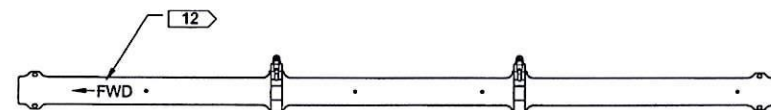
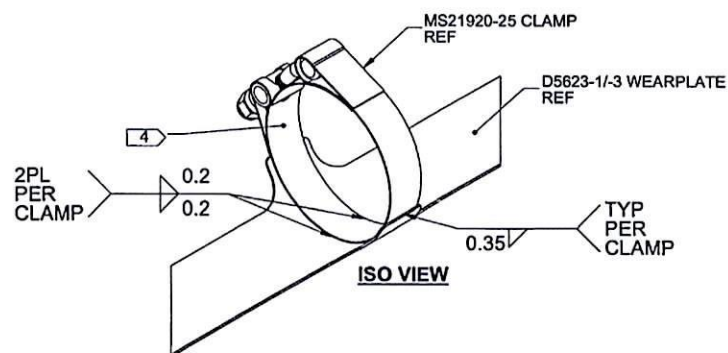
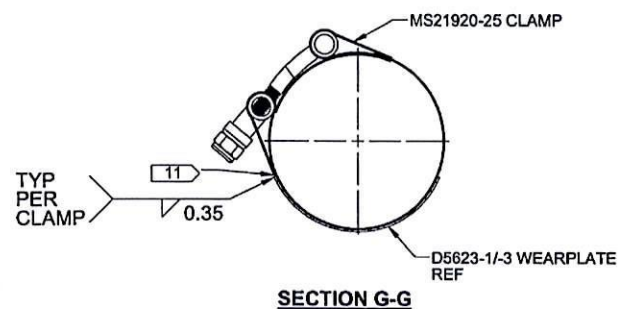
DRAWING NO. REV. A1
D5623 SHEET 1 OF 4
TITLE SCALE
WEARPLATE ASSY NTS

COPYRIGHT © 2018 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.





ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D5623-041	FWD WEARPLATE ASSY LH
2		X	D5623-043	AFT WEARPLATE ASSY LH
3	1		D5623-1	FWD WEARPLATE
4		1	D5623-3	AFT WEARPLATE
5	2	1	MS21920-25	CLAMP



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 SECTION 4.9
 - 3) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.060-0.080 TOTAL THICK, PER DART QSI 005 SECTION 4.9
 - 4) FINISH: COAT ENTIRE INNER (CONCAVE) SURFACE OF MS21920 CLAMP WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 SECTION 4.9
 - 5) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 6) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 7) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D5623-04X" USING FINE POINT PERMANENT INK MARKER PER DART QSI 044 SECTION 6.1
 - 9) WEIGHT: D5623-041 = 1.15 lbs, D5623-043 = 1.27 lbs
 - 10) WELDING: PER DART QSI 004
 - 11) INDEX MS21920-25 CLAMP TABS WITH WEARPLATE AT THIS LOCATION
 - 12) INDICATE FWD DIRECTION IN LOCATION SHOWN USING WHITE PAINT MARKER

A	NEW ISSUE	WK	18.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	WK		
DRAWN	RF		
CHECKED	VS		
MFG. APPR.	JFS		
APPROVED	HS		
DE APPR.	DE		
DATE	18.03.25		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D5623

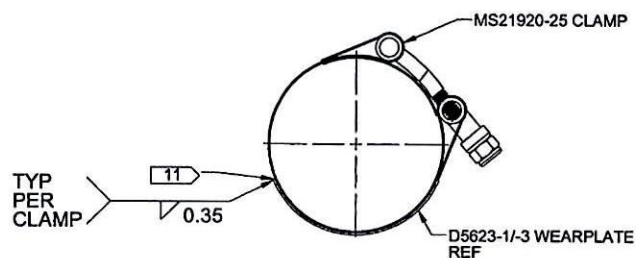
TITLE
WEARPLATE ASSY

REV. A
SHEET 1 OF 4
SCALE
NTS

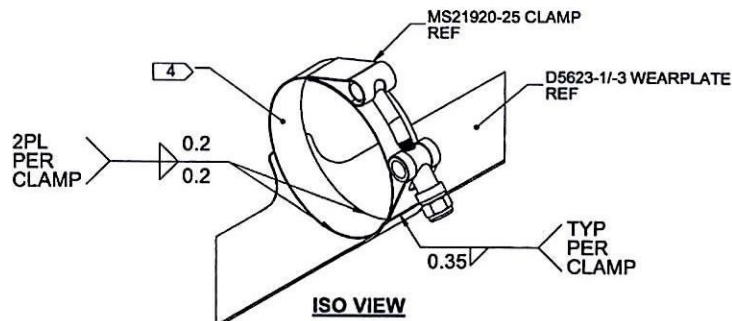
COPYRIGHT © 2018 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD

RELEASED
2018 AUG 15
ECN 18-785

ITEM	QTY -042	QTY -044	P/N	DESCRIPTION
1	X		D5623-042	FWD WEARPLATE ASSY RH
2		X	D5623-044	AFT WEARPLATE ASSY RH
3	1		D5623-1	FWD WEARPLATE
4		1	D5623-3	AFT WEARPLATE
5	2	1	MS21920-25	CLAMP



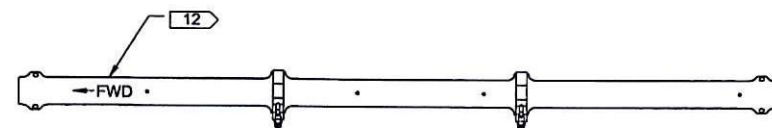
SECTION H-H



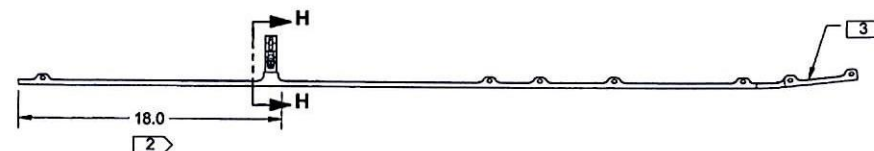
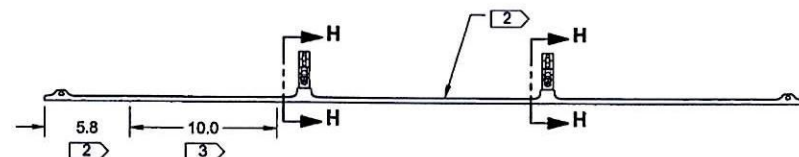
ISO VIEW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 SECTION 4.9
- 3) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.060-0.080 TOTAL THICK, PER DART QSI 005 SECTION 4.9
- 4) FINISH: COAT ENTIRE INNER (CONCAVE) SURFACE OF MS21920 CLAMP WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 SECTION 4.9
- 5) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) UNITS: INCHES UNLESS OTHERWISE NOTED
- 7) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D5623-04X" USING FINE POINT PERMANENT INK MARKER PER DART QSI 044 SECTION 6.1
- 9) WEIGHT: D5623-042 = 1.15 lbs, D5623-044 = 1.27 lbs
- 10) WELDING: PER DART QSI 004
- 11) INDEX MS21920-25 CLAMP TABS WITH WEARPLATE AT THIS LOCATION
- 12) INDICATE FWD DIRECTION IN LOCATION SHOWN USING WHITE PAINT MARKER



D5623-042 FWD WEARPLATE ASSEMBLY RH



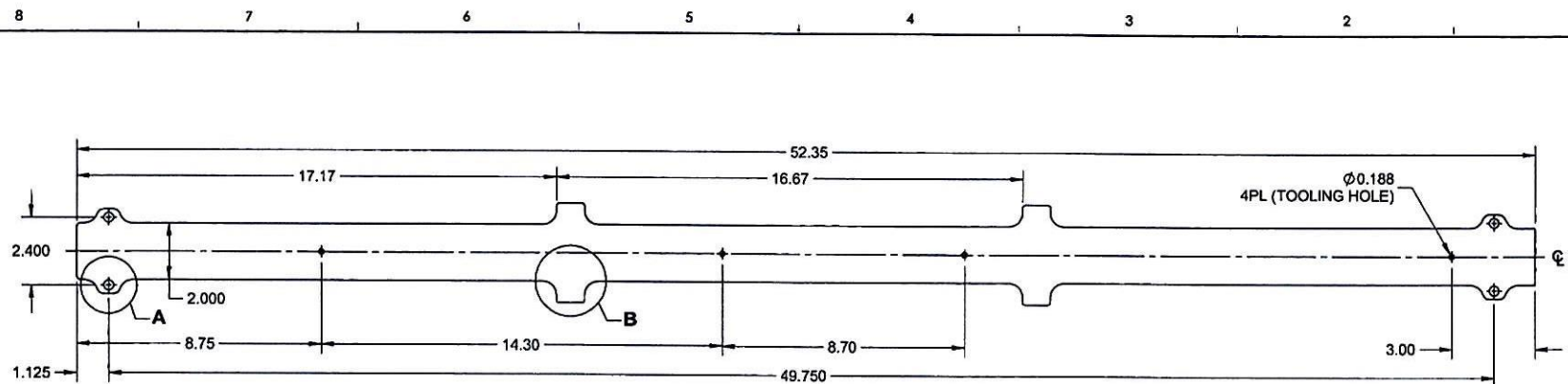
D5623-044 AFT WEARPLATE ASSEMBLY RH

RELEASED

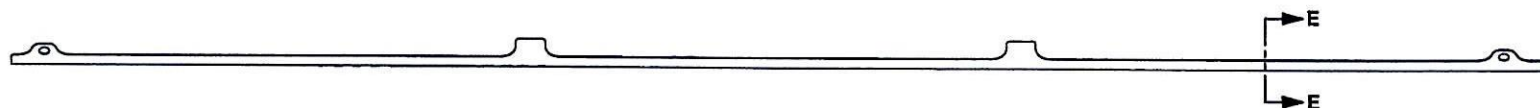
2018 AUG 15

APPROVED

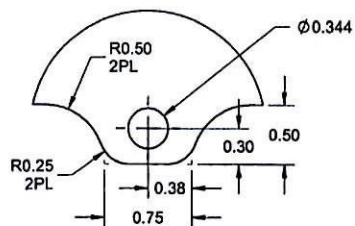
DESIGN	WK	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	JFS	D5623	SHEET 2 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
DATE	18.03.25	COPYRIGHT © 2018 BY DART AEROSPACE LTD.	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



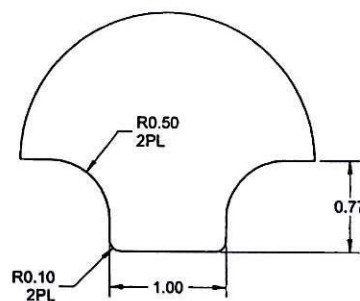
D5623-1F FLAT PATTERN



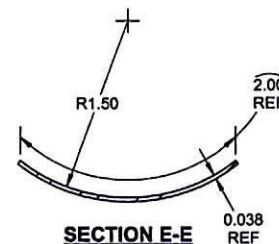
D5623-1 FWD WEARPLATE
(MAKE FROM D5623-1F)



DETAIL A



DETAIL B



SECTION E-E

RELEASED
2018 AUG 15

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.035 THICK (20 GAUGE)
PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D5623-1 = 1.11 lbs
- 8) ALL NON DIMENSIONED FEATURES PER CAD FILES D5623-1F_REVA.DXF

APPROVED

DESIGN	WK	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	JFS	D5623	SHEET 3 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
DATE	18.03.25	COPYRIGHT © 2018 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

